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FIG. 1

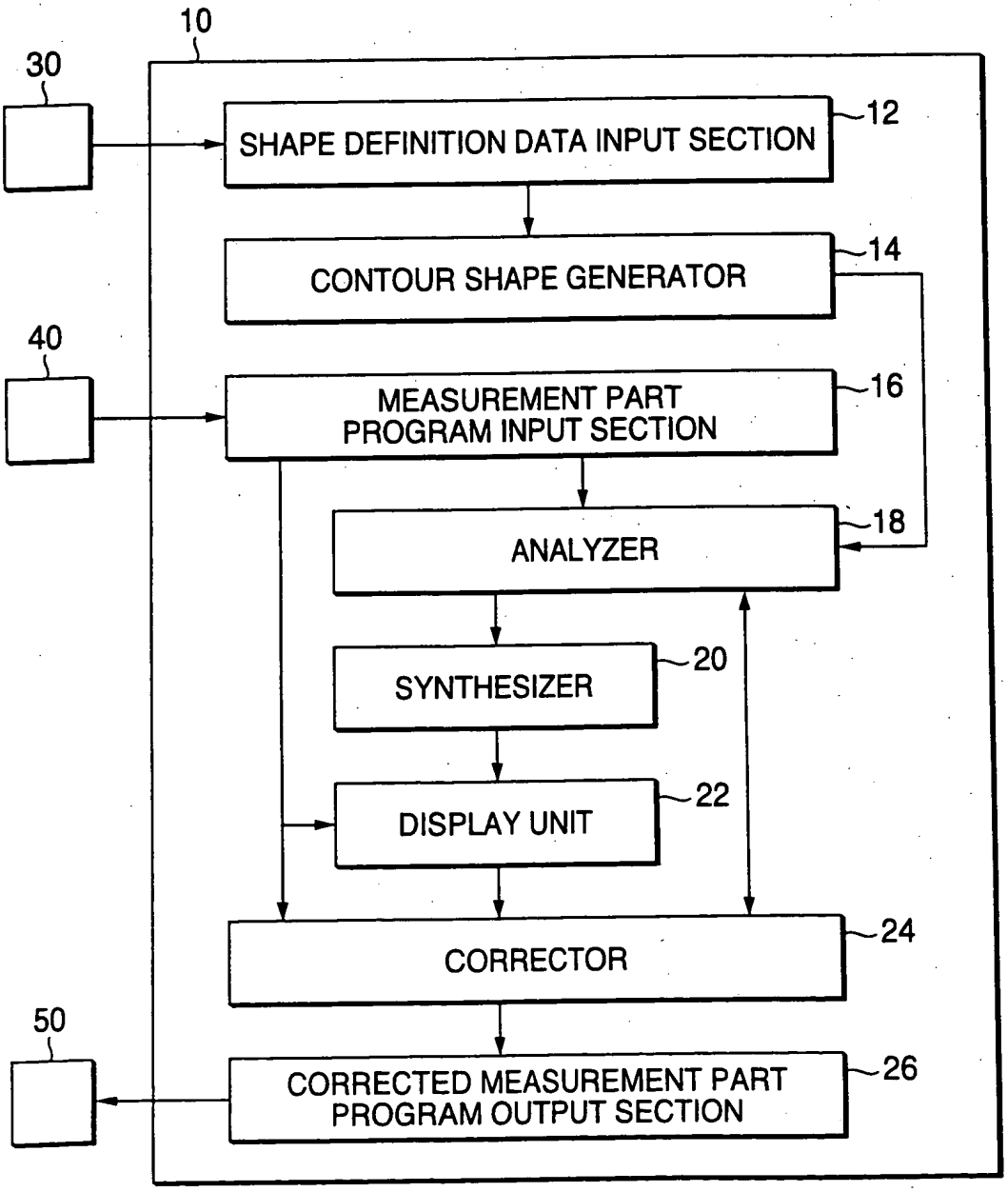

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FIG. 2

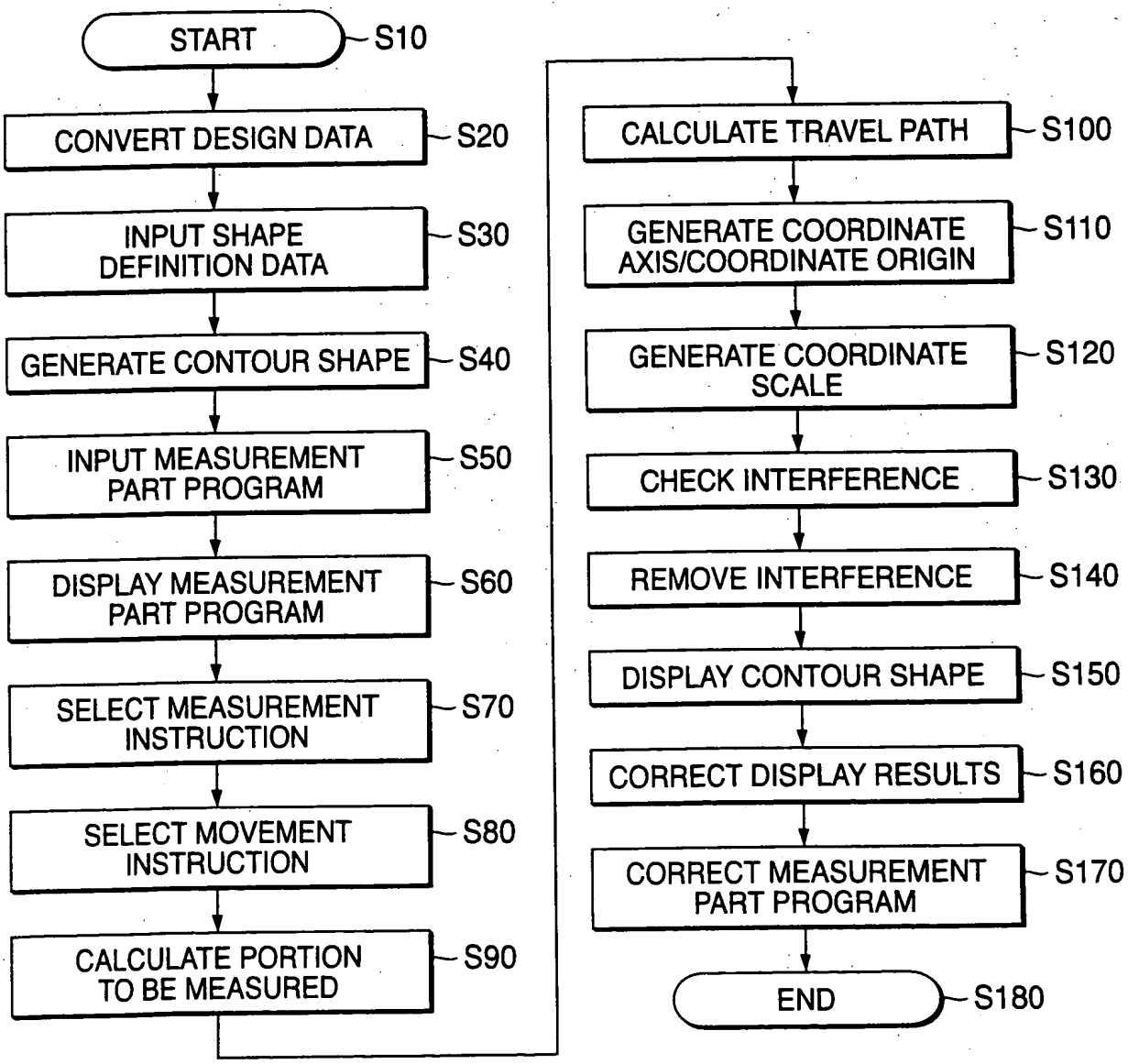

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FIG. 3

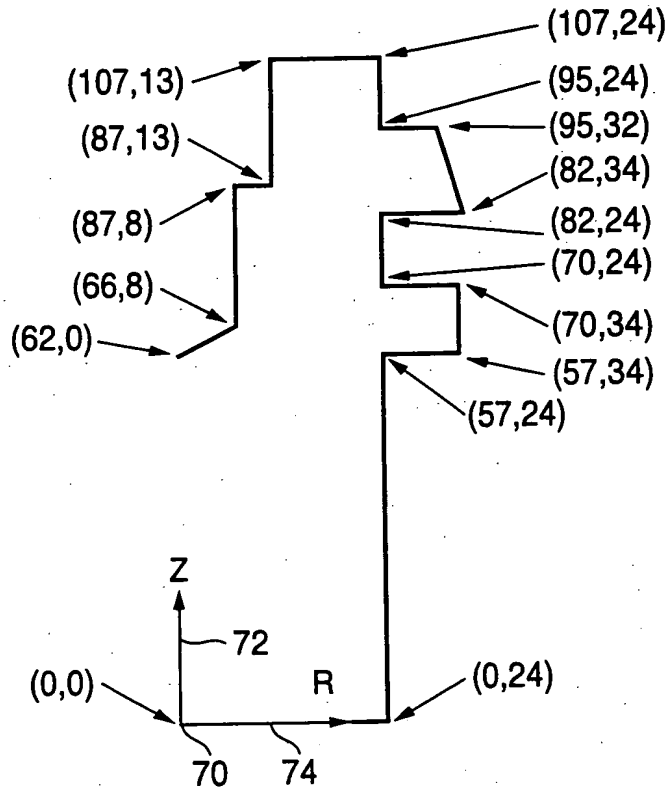

FIG. 4

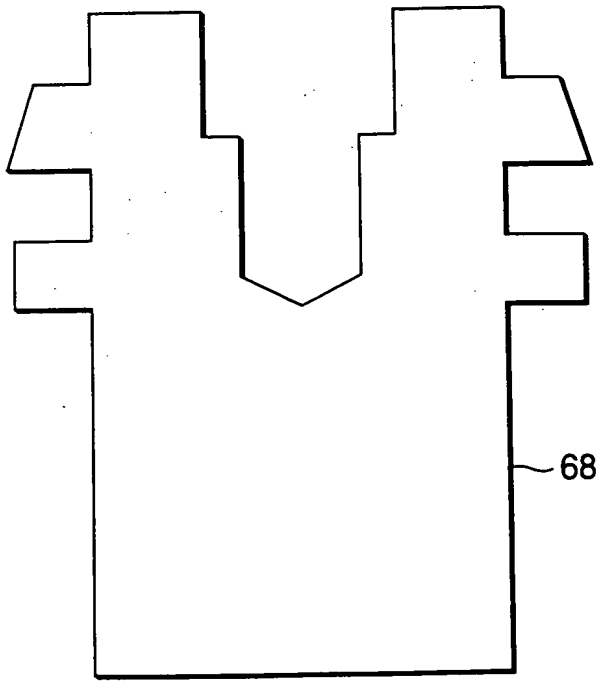

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FIG. 5

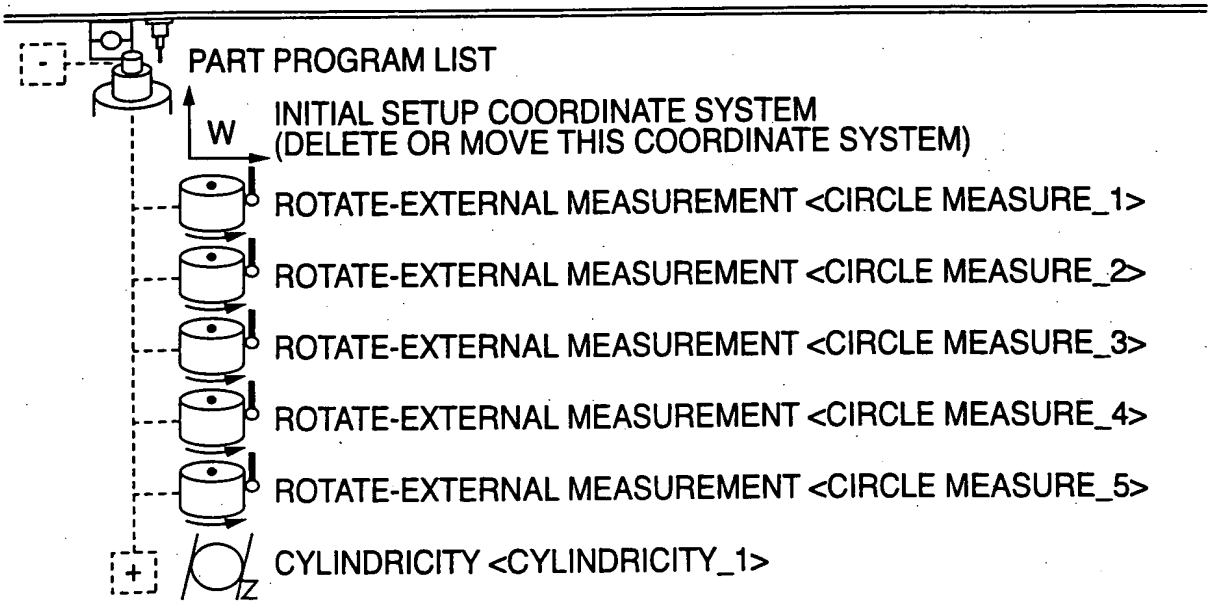

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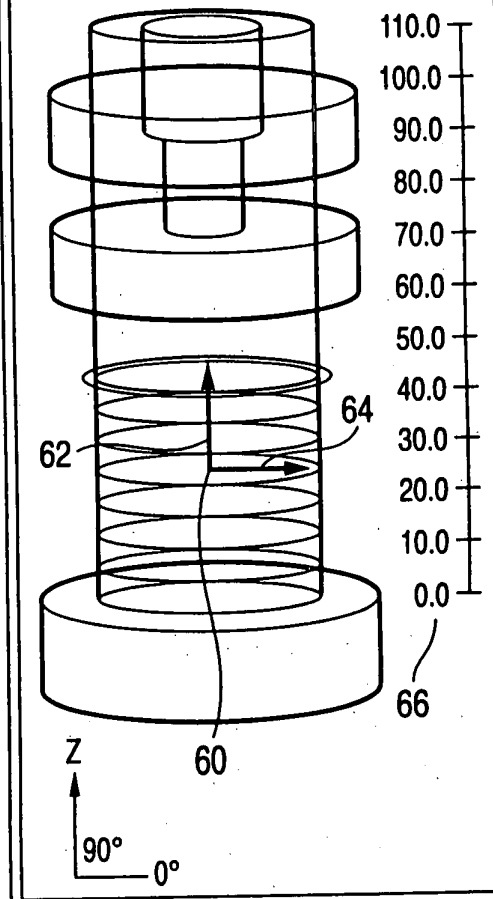
FIG. 6

MEASUREMENT CONDITION

	ELEMENT	MEASUREMENT POSITION	ANGLE POSITION	NUMBER OF SAMPLES	RETRACTION DISTANCE	CIRCLE SEGMENT MEASUREMENT
	<MEASURE_1>	20.00		7200		☐
	ROTATE-EXTERNAL MEASUREMENT	+5.00		7200		☐
	ROTATE-EXTERNAL MEASUREMENT	+5.00		7200		☐
	ROTATE-EXTERNAL MEASUREMENT	+5.00		7200		☐
	ROTATE-EXTERNAL MEASUREMENT	+5.00		7200	20.00	☐
Z	Z MOVEMENT	115.80				☐
R	R MOVEMENT	-7.82				
	ROTATE-INTERNAL MEASUREMENT	92.34		7200		☐
	ROTATE-INTERNAL MEASUREMENT	+2.00		7200		☐
	ROTATE-INTERNAL MEASUREMENT	+2.00		7200		☐
	ROTATE-INTERNAL MEASUREMENT	+2.00		7200		☐
	ROTATE-INTERNAL MEASUREMENT	+2.00		7200	3.00	☐
Z	Z MOVEMENT	+20.00				
R	R MOVEMENT	28.10				

REAL TIME DISPLAY <2D>

WORK PIECE VIEW WINDOW



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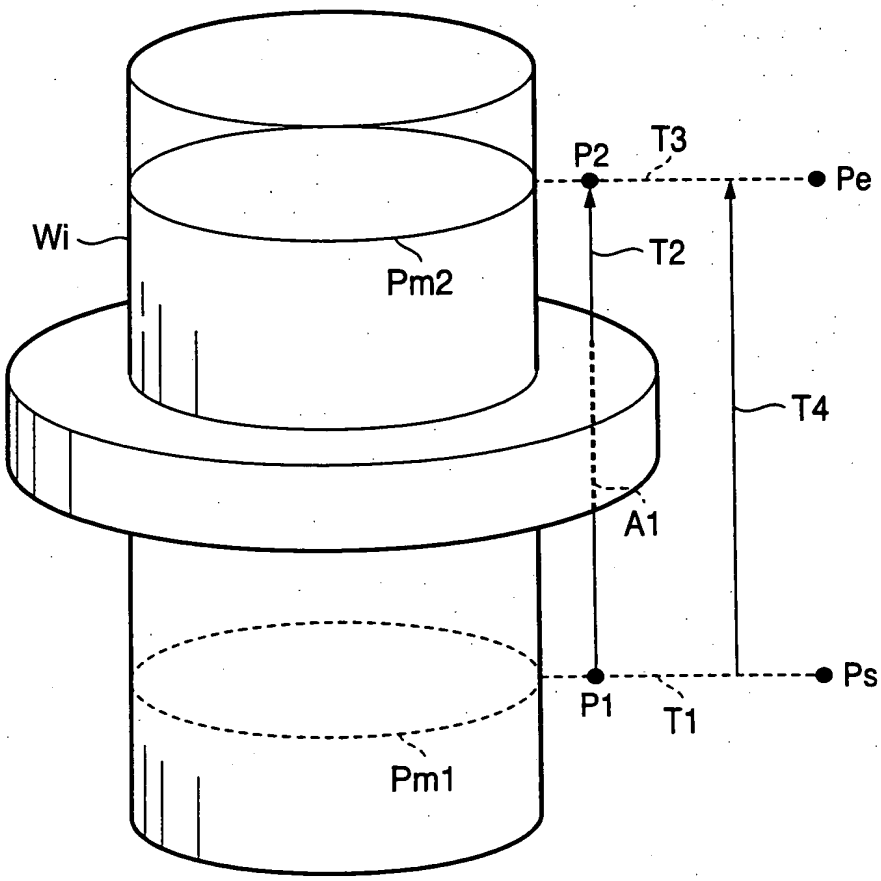
FIG. 7